

5/25

2

DART AEROSPACE LTD		Work Order:	23307
Description: Doubler		Part Number:	D3302-7
# 05.03.22 B2 Dwg: D3302 Rev. A B 04.11.25 NY		Qty:	18 20
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PA	05.05.20	20
2	MV	Cut blank: 2.100" x 2.100" Material: 5052-H32 or 6061-T6(QQ-A-250/8 or QQ-A-250/11) 0.040" thick (M5052H32S.040 or M6061T6S.040) Identify for D3302-7 Batch: M17460	En	05.06.22	20
3	MV	Machine as per Folio FA453 and Dwg D3302 Identify as D3302-7	En	05.06.22	20
4	QC2	Inspect parts as they come off the CNC machine	En	05.06.22	20
5	QC8	Second check	En	05.06.22	20
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	FF	05.06.23	20
7	QC5	Inspect work to Step 6	2	05.06.23	18
8	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.05	18
9	QC3	Inspect Chemical Conversion Coat	2	05.07.06	18
10	ST	Identify and Stock	CL	05/07/06	18
11	AC	Cost / part 4.32	5.05	05.08.02	18
12	DC	Close W/O 4.23 Inspect Level 21	PA	05/07/07	18


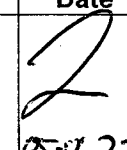
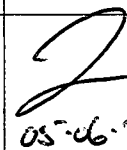
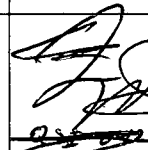
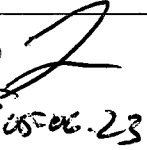
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Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	


RELEASED
05/07/07

1-0332

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23307		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-23	6	2x3302-7 no good rivet holes oversized by 0.020", supposed to be .018	 QSI 042 05-07-02	SCRAP & destroy	 05-06-23	 05-06-23	 05-06-23	 05-06-23

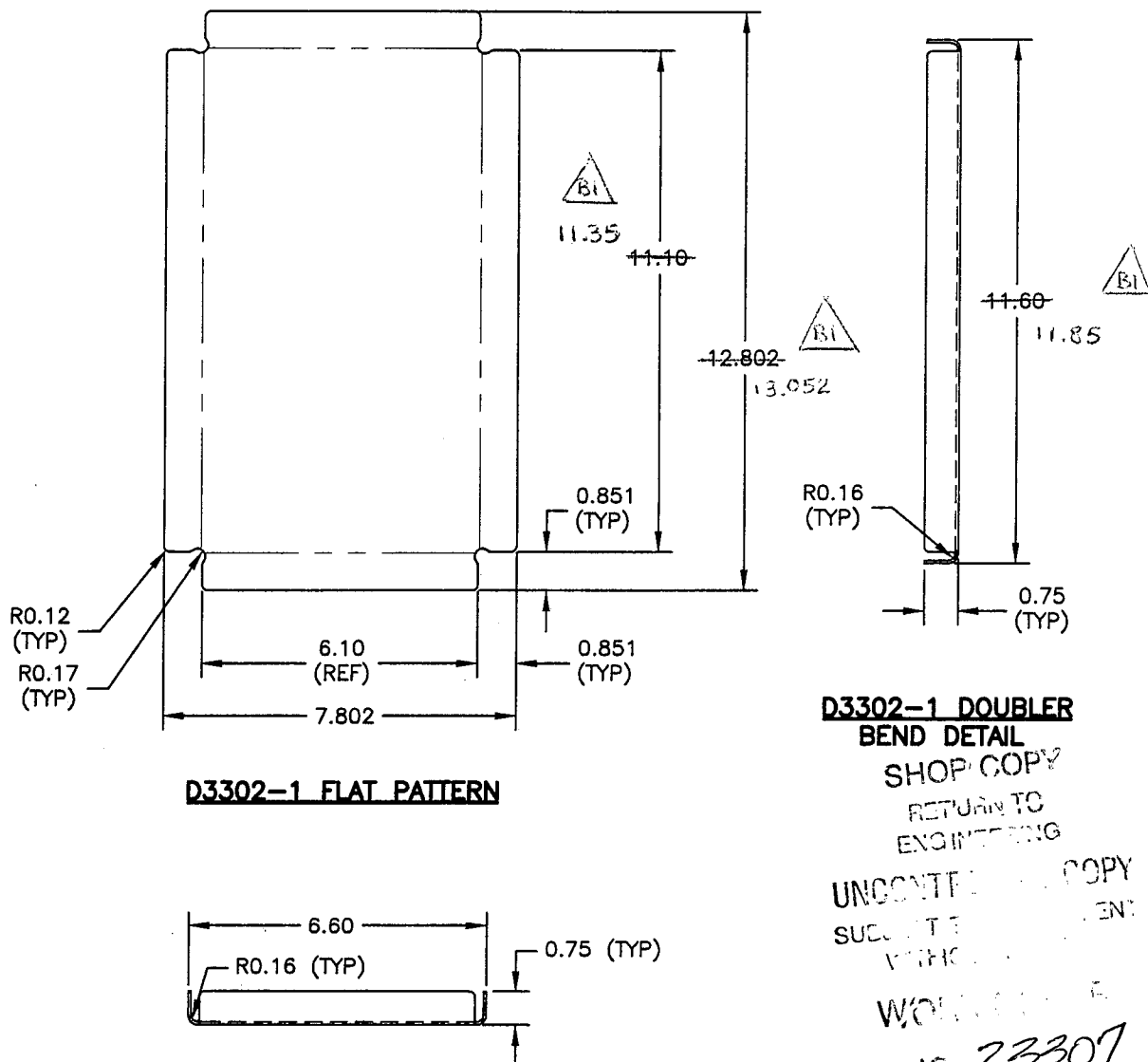
Part No: D.3302-7 PAR #: _____ Fault Category: Prod/Fin. ass. med-Small NCR: Yes No DQA:  Date: 05/07/07

NOTE: Date & initial all entries QA: N/C Closed:  Date: 05.07.07



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
Bi	RF 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	05.03.21	7.25 WAS 7.34; 8.952 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3	

RELEASED
04.11.23



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

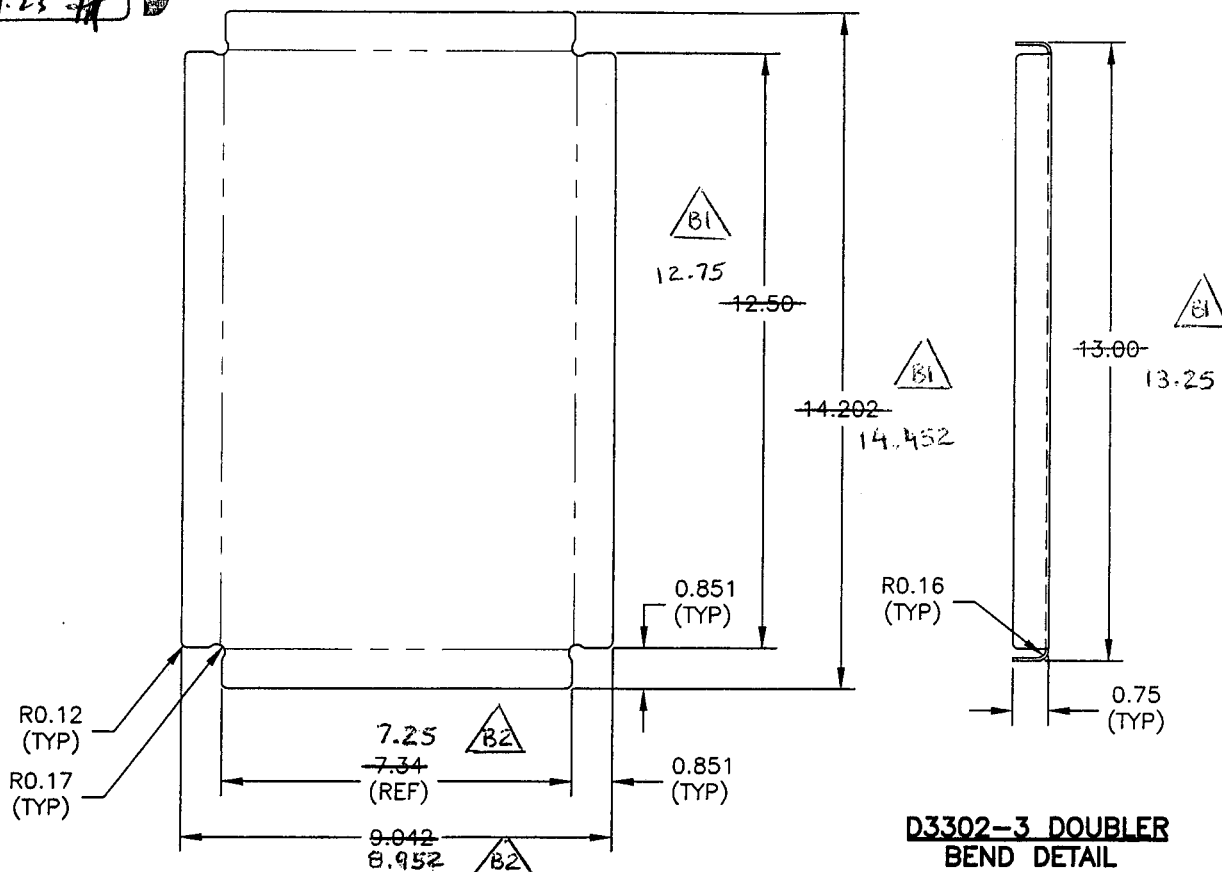
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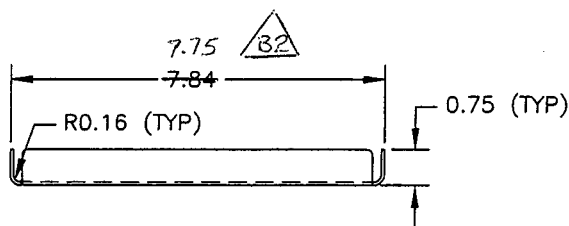
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 H



D3302-3 FLAT PATTERN

D3302-3 DOUBLER
BEND DETAIL



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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WORK COPY
23307

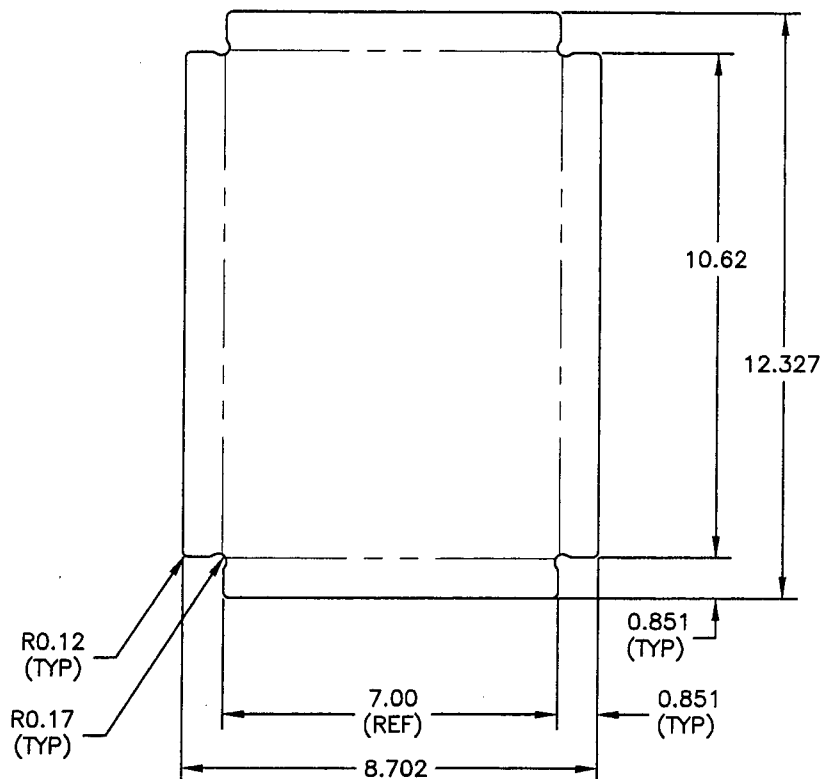
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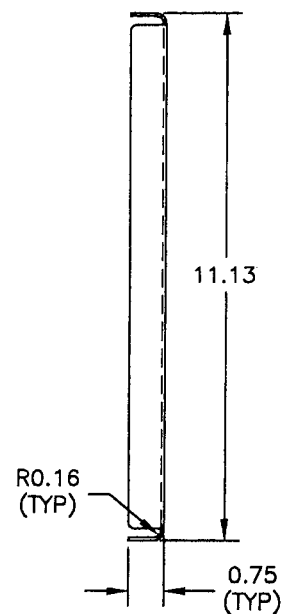
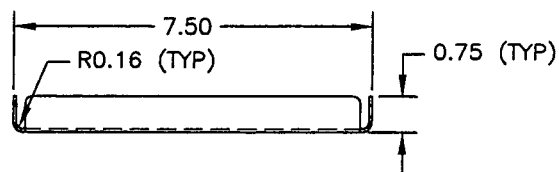


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 [Signature]



D3302-5 FLAT PATTERN



**D3302-5 DOUBLER
BEND DETAIL**

SHOP CO.
RETURN TO
ENGINEER

UNCONF
SUBJECT
V. HK

WOL.

NO. 23307

D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

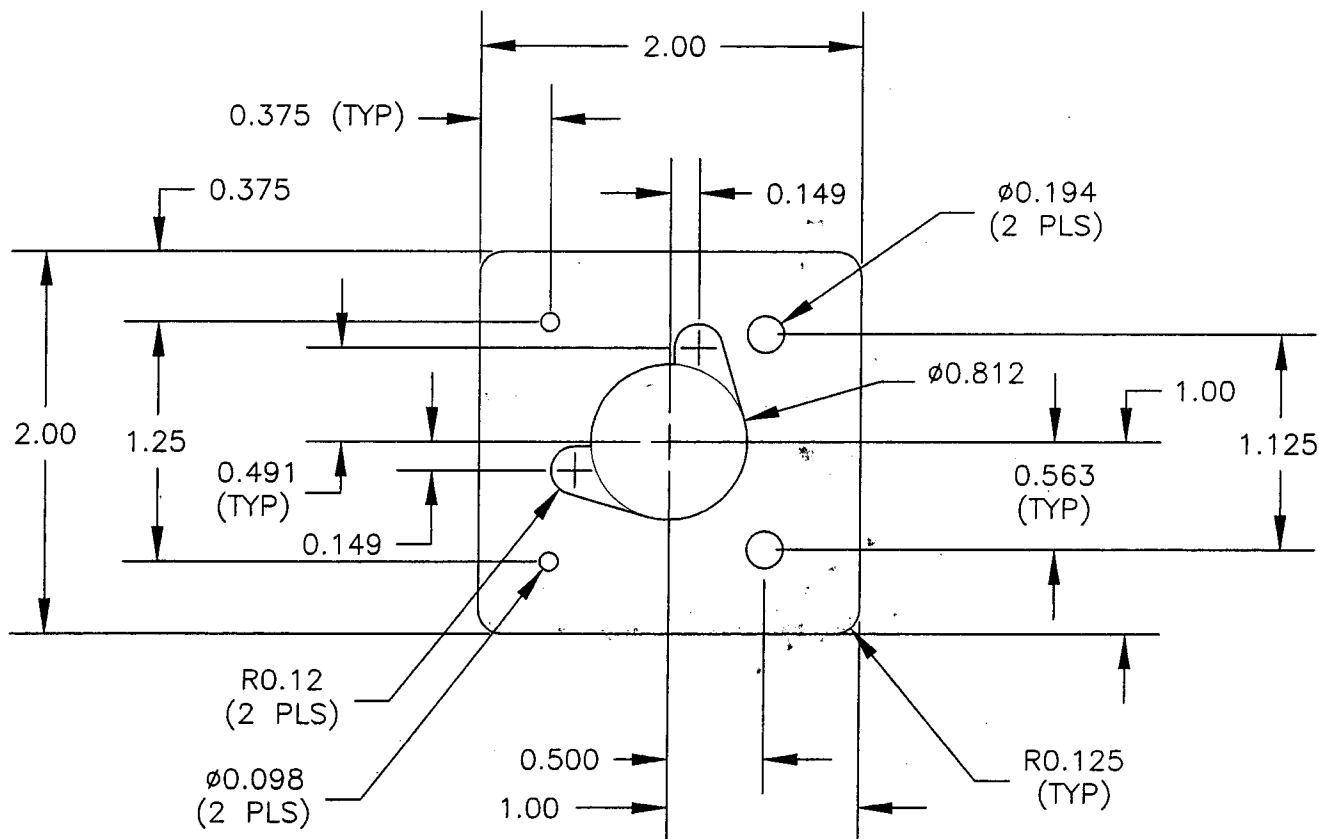
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:1

RELEASED
04.11.23



D3302-7

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11) 0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 23307

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 12, 2005
04:28 pm

Work Order No : 0023307
Project Name : D3302-7
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D3302-7
Description : Doubler
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 05-12-05
Est Finish Date : 06-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00